

85579

Ship Tuesday Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/11/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/11/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Run Start *NR1*

Approvals: Process Plan: *ME* Date: 12-06-11

Tooling: _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr.	Revision Nbr
E4662	A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

6061, 125"

Dwg Rev:

Prog Rev: 1A

2- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85579

85579

Page 2

Monday, June 11, 2012 11:18:59 AM

Item ID: E4662-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Co-Pilot Panel
Start Date: 6/11/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/11/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8/2/06/14		(u)			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1		CF 12-6-11	
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				IX			ML 12/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85579***85579***

Page 3

Monday, June 11, 2012 11:18:59 AM

Item ID: E4662-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Co-Pilot Panel

Stop ***NS2***

Start Date: 6/11/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: SHIP

0.00

150

Packaging

Memo

0.00

Packaging

Per 6/12 ①

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML 12/06/1212-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 11, 2012 11:18:58 AM

Page 1

Work Order ID: 85579

Parent Item: E4662-1

Parent Item Name: Co-Pilot Panel

Start Date: 6/11/2012

Required Date: 6/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.06.04 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	58.0945	2.3344	2.4572632		Jm 12-6-11	
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT021		58.0945					
						121473		58.0945		121473			

Dart Aerospace Ltd

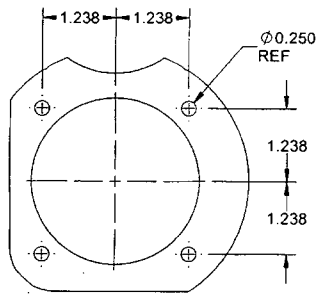
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

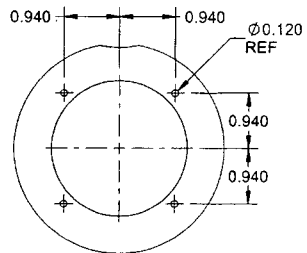
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

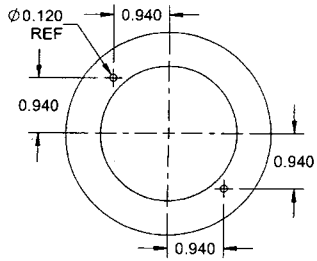
NOTE: Date & initial all entries



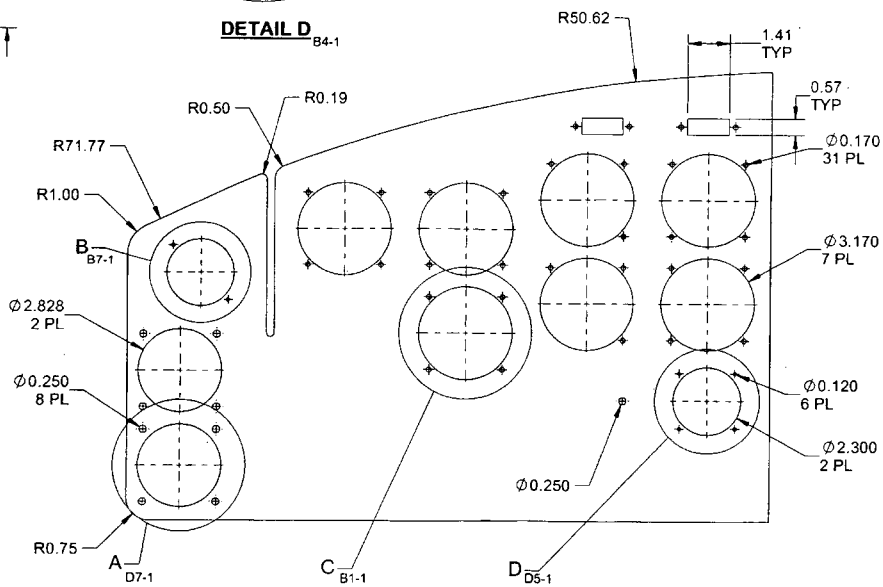
DETAIL A
B6-1



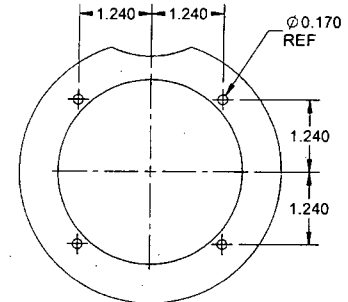
DETAIL D
B4-1



DETAIL B
C6-1



E4662-1 CO-PILOT PANEL



DETAIL C
B5-1

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.125
OR
6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.60 lbs

RELEASED
R 2012-06-01
JMP

A		NEW ISSUE		DC	12.05.28
REV.	DESCRIPTION			BY	DATE
DESIGN	JB	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA			
DRAWN	JC				
CHECKED	JB	DRAWING NO.	REV. A		
MFG. APPR.	JB	E4662	SHEET 1 OF 4		
APPROVED	MP	TITLE	SCALE		
DE APPR.	N/A	INSTRUMENT PANEL		NTS	
DATE	12.05.28	COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.			

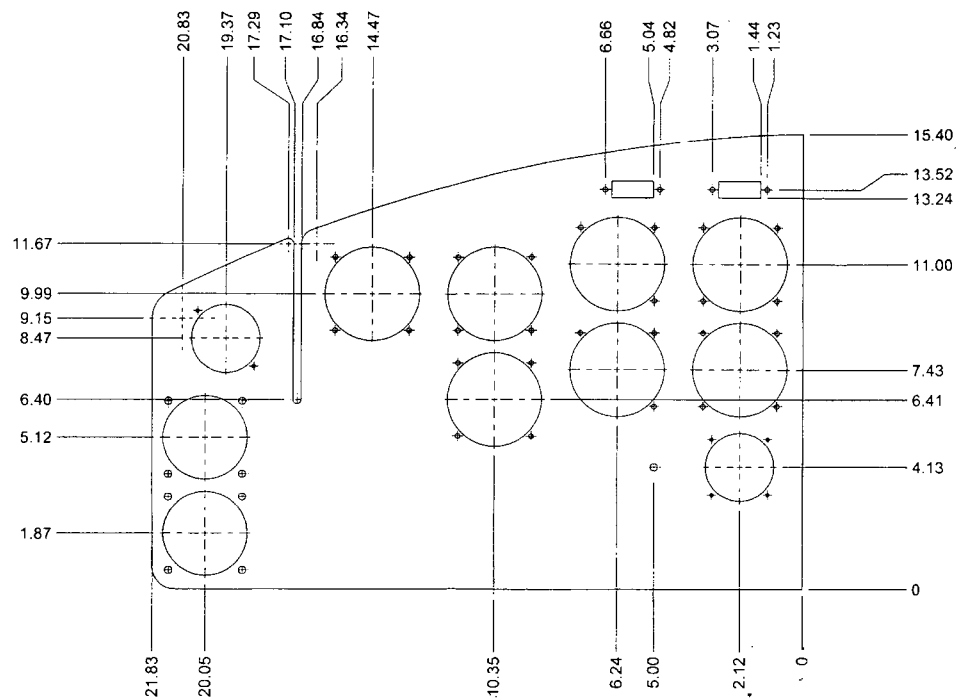
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



E4662-1 CO-PILOT PANEL
AUXILIARY VIEW

RELEASED
2012-06-01

DESIGN	BC	EAGLE COPTERS LTD	
DRAWN	BC	CALGARY, ALBERTA, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	E4662	SHEET 2 OF 4
APPROVED	BC	TITLE	SCALE
DE APPR.	N/A	INSTRUMENT PANEL	NTS
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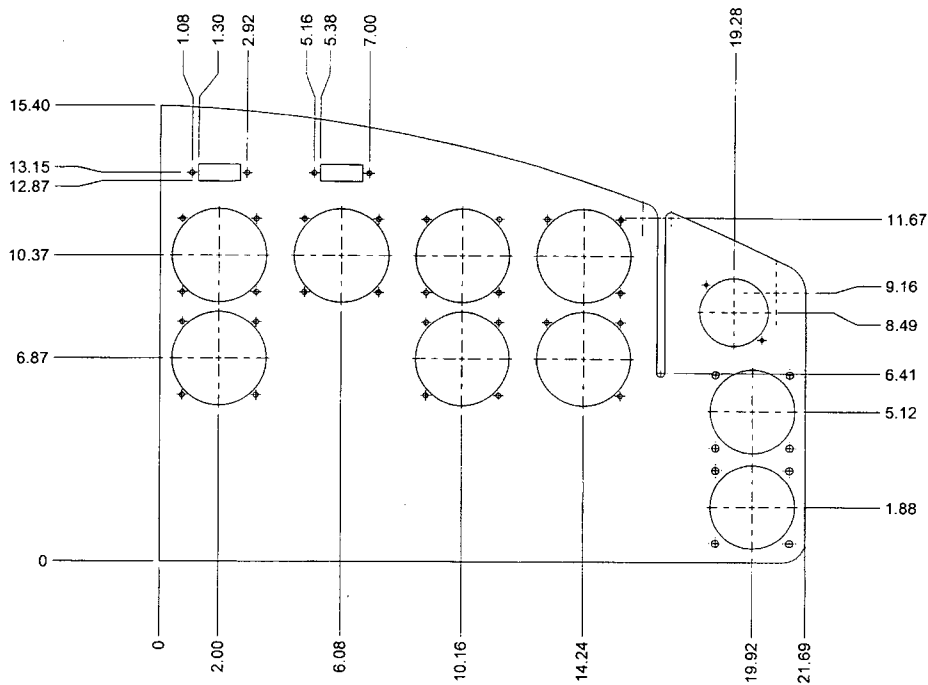
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



E4662-3 PILOT PANEL
AUXILIARY VIEW

RELEASED
2012-06-01
AP

DESIGN	BE	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	BC		
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	E4662	SHEET 4 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	N/A	INSTRUMENT PANEL	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	85579
Description: Co-Pilot Panel		Part Number:	E4662-1
Inspection Dwg: E4662 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.238"	+/- 0.010	1.239"	✓		✓	mm01
1.238"	+/- 0.010	1.240"	✓		✓	mm01
Ø 0.250"	+0.005 -0.001	Ø 0.252"	✓		✓	mm01
1.238"	+/- 0.010	1.238"	✓		✓	mm01
1.238"	+/- 0.010	1.239"	✓		✓	mm01
Ø 0.120"	+0.004 -0.001	Ø 0.122"	✓		✓	mm01
Ø 0.940"	+/- 0.010	Ø 0.940"	✓		✓	mm01
Ø 0.940"	+/- 0.010	Ø 0.941"	✓		✓	mm01
Ø 0.940"	+/- 0.010	Ø 0.940"	✓		✓	mm01
Ø 0.940"	+/- 0.010	Ø 0.940"	✓		✓	mm01
Ø 0.940"	+/- 0.010	Ø 0.940"	✓		✓	mm01
Ø 0.940"	+/- 0.010	Ø 0.942"	✓		✓	mm01
Ø 0.120"	+0.004 -0.001	Ø 0.123"	✓		✓	mm01
Ø 0.940"	+/- 0.010	Ø 0.940"	✓		✓	mm01
Ø 0.940"	+/- 0.010	Ø 0.942"	✓		✓	mm01
Ø 2.828"	+0.002 -0.001	Ø 2.828"	✓		✓	mm01
Ø 0.250"	+0.005 -0.001	Ø 0.251"	✓		✓	mm01
R 71.77"	+/- 0.030					
R 1.00"	+/- 0.030	1.00"	✓		RG	
R 0.500"	+/- 0.030	0.50"	✓		RG	
R 0.19"	+/- 0.030	0.19"	✓		RG	
R 50.62"	+/- 0.030					
R 0.75"	+/- 0.030	0.75"	✓		RG	

Measured by:	Jm	Audited by:	Ø	Preliminary Approval:	
Date:	12-6-11	Date:	12/6/11	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DART AEROSPACE LTD		Work Order:	85579
Description: C-101 Panel		Part Number:	F4662-1
Inspection Dwg: F4662 Rev: 17		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.41"	+/- 0.030	1.412"	✓		V	mm01
0.57"	+/- 0.030	0.562"	✓		V	mm01
Ø 0.170"	+0.004 -0.001	0.172"	✓		V	mm01
Ø 3.170"	+0.012 - 0.001	3.170"	✓		V	mm01
Ø 0.120"	+0.004 -0.001	0.121"	✓		V	mm01
Ø 2.300"	+0.012 - 0.001	2.299"	✓		V	mm01
0.125"	+/- 0.010	0.123"	✓		V	mm01
Ø 0.250"	+0.005 -0.001	0.251"	✓		V	mm01
1.240"	+/- 0.010	1.240"	✓		V	mm01
1.240"	+/- 0.010	1.240"	✓		V	mm01
Ø 0.170"	+0.005 -0.001	0.171"	✓		V	mm01
1.240"	+/- 0.010	1.243"	✓		V	mm01
1.240"	+/- 0.010	1.244"	✓		V	mm01
11.67"	+/- 0.030	11.675"	✓		V	mm01
9.99"	+/- 0.030	9.996"	✓		V	mm01
9.15"	+/- 0.030	9.16"	✓		V	mm01
8.47"	+/- 0.030	8.48"	✓		V	mm01
6.40"	+/- 0.030	6.397"	✓		V	mm01
5.12"	+/- 0.030	5.124"	✓		V	mm01
1.87"	+/- 0.030	1.88"	✓		V	mm01
21.83"	+/- 0.030	21.83"	✓		MT	US01
20.05"	+/- 0.030	20.05"	✓		MT	US01
10.35"	+/- 0.030	10.365	✓		MT-V	Passing

Measured by: Jm	Audited by: S	Preliminary Approval:
Date: 12-6-11	Date: 17/06/14	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DART AEROSPACE LTD		Work Order:	85574
Description: <i>Co-Pilot Panel</i>		Part Number:	E4662-1
Inspection Dwg: <i>E4662</i> Rev: <i>A</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.24"	± 0.030	6.247"	✓		✓	mm01
6.00"	± 0.030	6.001"	✓		✓	mm01
2.12"	± 0.030	2.13"	✓		✓	mm01
4.13"	± 0.030	4.138"	✓		✓	mm01
6.41"	± 0.030	6.424"	✓		✓	mm01
7.43"	± 0.030	7.442"	✓		✓	mm01
11.00"	± 0.030	11.007"	✓		✓	mm01
13.24"	± 0.030	13.24"	✓		MT	mm HB-01
13.52"	± 0.030	13.52"	✓		MT	HB01
15.40"	± 0.030	15.40"	✓		MT	HB01
1.23"	± 0.030	1.217"	✓		✓	mm01
1.44"	± 0.030	1.447"	✓		✓	mm01
3.07"	± 0.030	3.069"	✓		✓	mm01
4.82"	± 0.030	4.824"	✓		✓	mm01
5.04"	± 0.030	5.046"	✓		✓	mm01
6.66"	± 0.030	6.669"	✓		✓	mm01
14.47"	± 0.030	14.47"	✓		MT	HB-01
16.34"	± 0.030	16.34"	✓		MT	HB-01
16.84"	± 0.030	16.84"	✓		MT	HB01
17.10"	± 0.030	17.10"	✓		MT	HB01
17.29"	± 0.030	17.29"	✓		MT	HB01
19.37"	± 0.030	19.37"	✓		MT	HB01
20.83"	± 0.030	20.83"	✓		MT	HB01

Measured by:	<i>JM</i>	Audited by:	<i>8</i>	Preliminary Approval:	
Date:	<i>12-6-11</i>	Date:	<i>12/6/14</i>	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	